

DART

DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3288	REV. C SHEET 1 OF 3
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY	SCALE NTS
A	04.05.17	NEW ISSUE	
B	05.03.16	CHANGE INSERTS	
C	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

RELEASED

07.02.12

UNDER REVIEW07.05.31
COMPATIBILITY
ISSUE

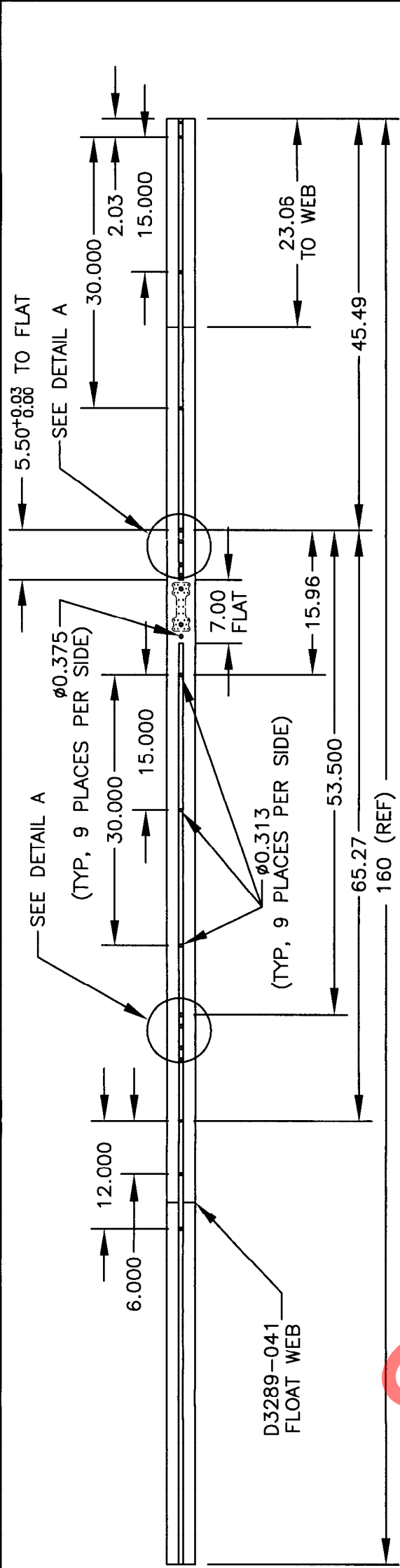
Qty	Part Number	Description
041		
X	D3288-041	SKIDTUBE ASSEMBLY
1	D2600-1-240	EXTRUSION
1	D2647	CAP
1	D2646	AFT CAP
9	D2649	CROSS BOLT SPACER
9	D3275-1	CROSS BOLT SPACER
2	D3286-1	DOUBLER
2	D3286-3	SPACER
1	D3289-041	FLOAT WEB
1	D3413-1	RING
1	D3415-041	NUT PLATE
1	D3535-15	WEARSHOE
1	D3535-21	WEARSHOE
1	D3535-35	WEARSHOE
1	D3535-41	WEARSHOE
1	D3536-15	GASKET
1	D3536-21	GASKET
1	D3536-35	GASKET
1	D3536-41	GASKET
7	D3537-1	WEARPAD
1	D3537-3	WEARPAD
64	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
66	AN3C4A	BOLT
1	AN4C5A	BOLT
1	AN960C416	WASHER
66	AN960C10L	WASHER
2	CCR264SS3-3	RIVET
2	CR3212-4-03	RIVET
52	CR3212-4-04	RIVET
2	NAS1515H3L	WASHER

GENERAL NOTES:

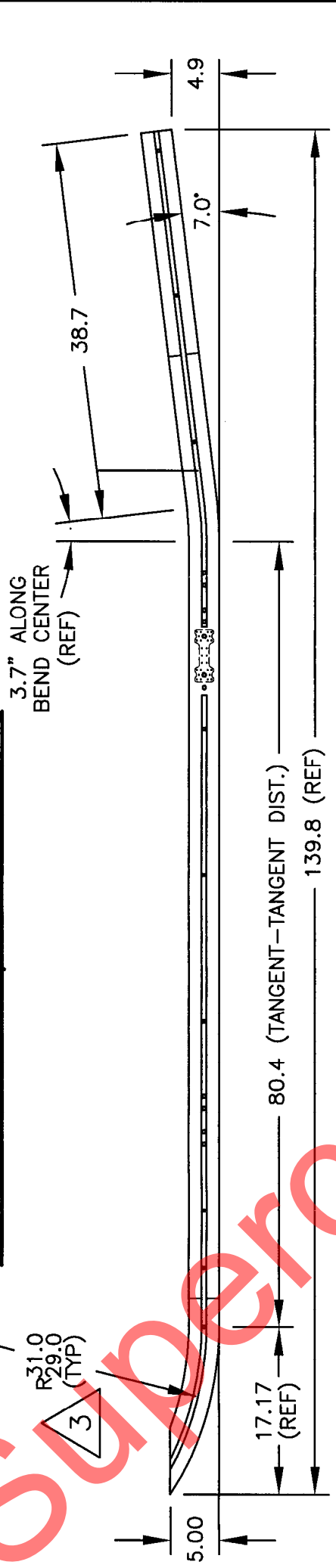
1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3289-041 FLOAT WEB INTO D3288-1 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH:
 - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
 - POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3288-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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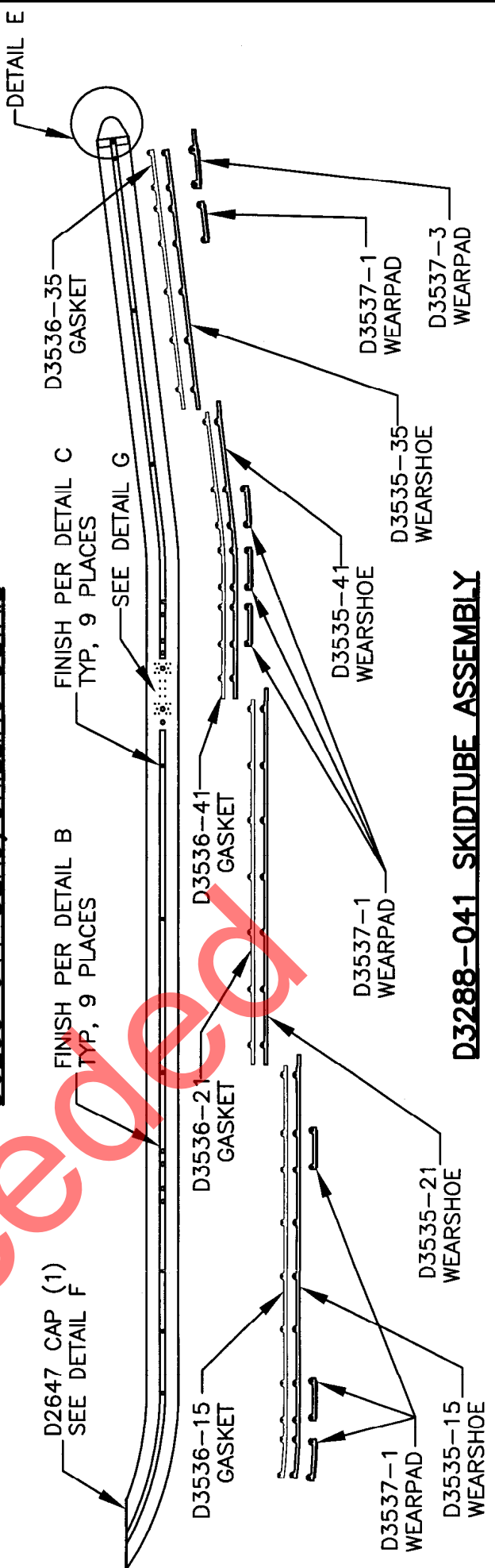
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D3288-041 DRILLING/ASSEMBLY DETAIL



D3288-041 BEND/DRILLING DETAIL

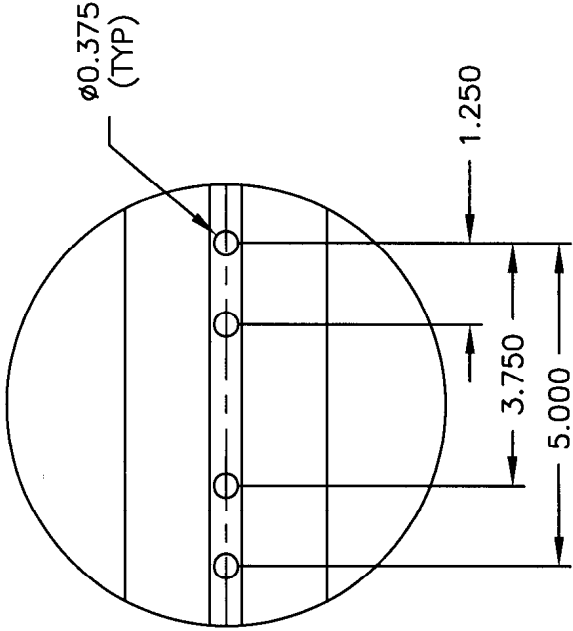


D3288-041 SKIDTUBE ASSEMBLY

RELEASED
07.07.12
UNDER REVIEW
07.05.12

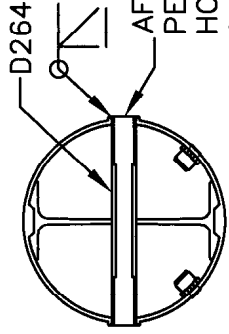
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				D3288	SHEET 2 OF 3
		DATE		TITLE	SCALE
		06.12.19		SKIDTUBE ASSEMBLY	1:15

DETAIL A: DRILL DETAIL



DETAIL B

FOR $\phi 0.375$ HOLES ONLY

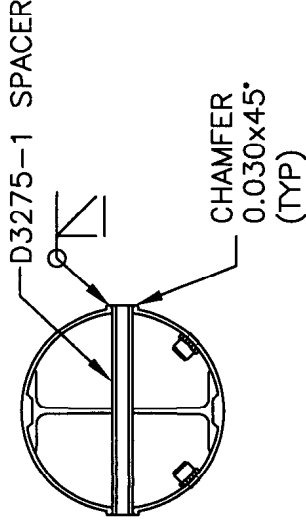


AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR $\phi 0.375$
HOLES ONLY:

1. CHAMFER HOLE $0.030 \times 45^\circ$
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO $\phi 0.313 \times 0.75$ DEEP

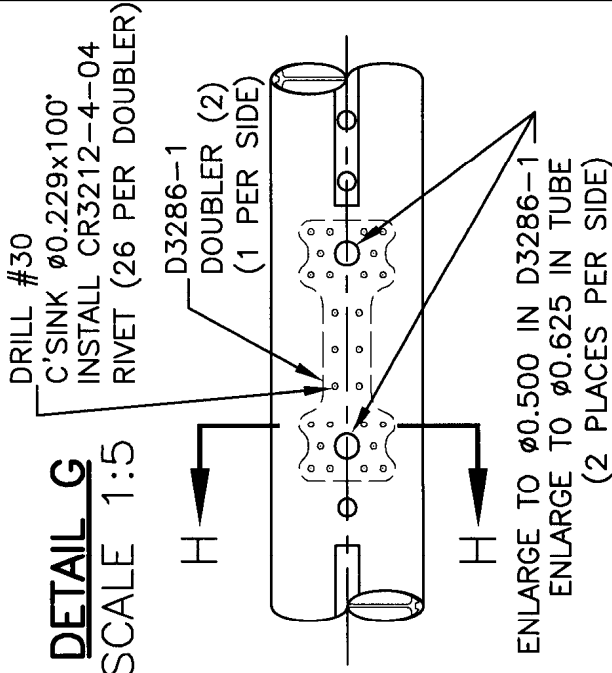
DETAIL C

FOR $\phi 0.313$ HOLES ONLY



DETAIL G

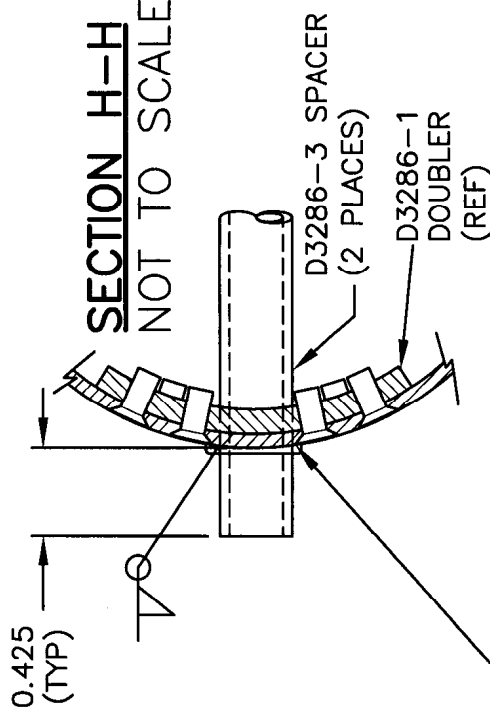
SCALE 1:5



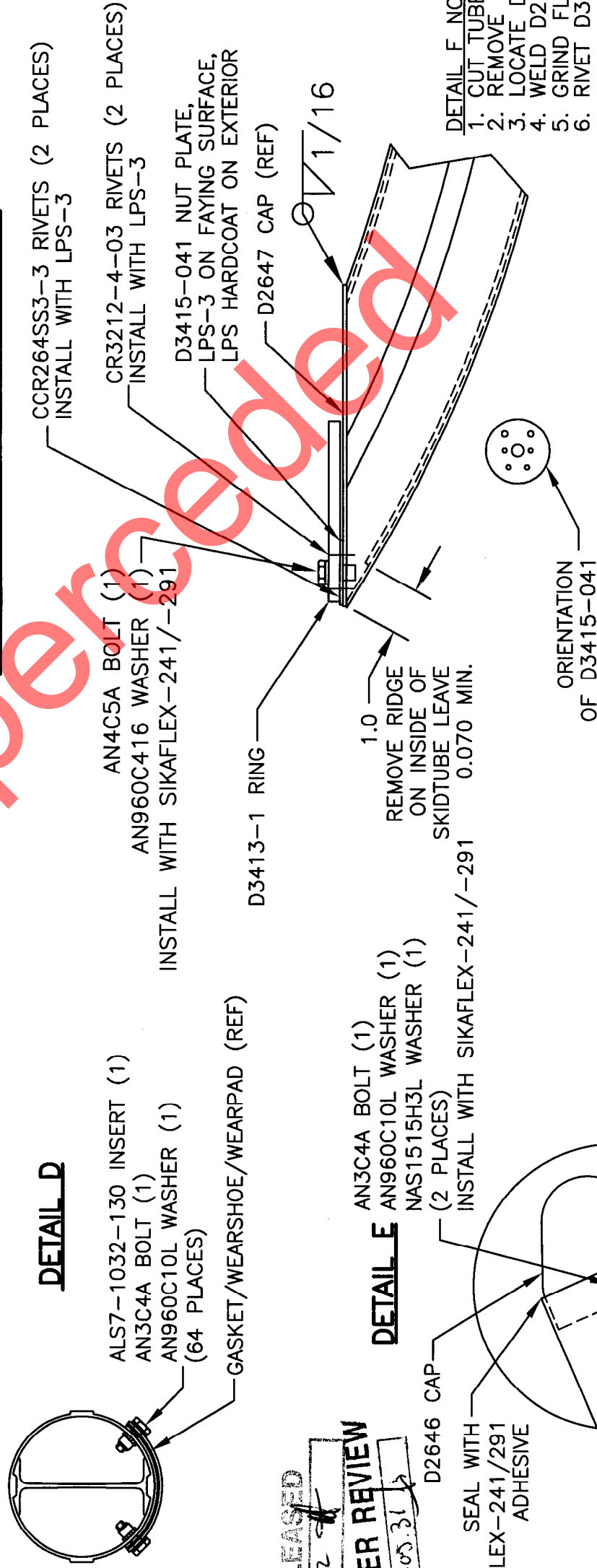
DRILL #30

C'SINK $\phi 0.229 \times 100'$
INSTALL CR3212-4-04
RIVET (26 PER DOUBLER)

SECTION H-H
NOT TO SCALE



DETAIL F: END FINISHING DETAIL



DETAIL D

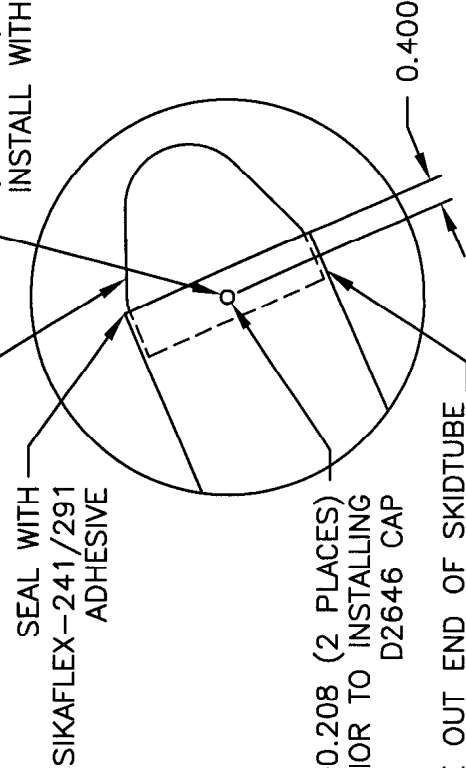
- ALS7-1032-130 INSERT (1)
- AN3C4A BOLT (1)
- AN960C10L WASHER (1)
- (64 PLACES)
- GASKET/WEARSHOE/WEARPAD (REF)

- CCR264SS3-3 RIVETS (2 PLACES)
- INSTALL WITH LPS-3
- CR3212-4-03 RIVETS (2 PLACES)
- INSTALL WITH LPS-3

- D3413-1 RING
- REMOVE RIDGE ON INSIDE OF SKIDTUBE LEAVE 0.070 MIN.
- 1.0
- ORIENTATION OF D3415-041

DETAIL E

- AN3C4A BOLT (1)
- AN960C10L WASHER (1)
- NAS1515H3L WASHER (1)
- (2 PLACES)
- INSTALL WITH SIKAFLEX-241/-291



RELEASED
07.02.12

UNDER REVIEW
07.05.31

SEAL WITH
SIKAFLEX-241/291
ADHESIVE

DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH

$\phi 0.208$ (2 PLACES)
DRILL PRIOR TO INSTALLING
D2646 CAP

BORE OUT END OF SKIDTUBE
TO 0.75 DEPTH AND 0.070 WALL

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DATE	06.12.19	DRAWING NO.	D3288
		TITLE	SKIDTUBE ASSEMBLY
		REV. C	SHEET 3 OF 3
		SCALE	1:3